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**D5336-041**  
**Job Sheet 196388**



**Part No:** D5336-041

**Job Qty:** 1 pcs

**Part Name:** Basket Lid Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 6/12/19

**Job Tracking No:**

**Due Date:** 7/12/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:** SIOP

**Note:** DWG REV B SHEETS 1,2,3,7 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 AS PER REV.B DD VERF:JFS

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |           | Sign-off    |
|-------|------------------------|----------|------------|----------|-----------|---------|-----------------------------|-----------|-------------|
|       |                        |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       | Lead Time |             |
| 100   | Large Fab - Basket - 1 | 1<br>pcs | 7/12/19    | 7/12/19  | 0.00      | 8.02    | Large Fab - 1               |           |             |
|       |                        |          |            |          |           |         | Large Fab - 10              |           |             |
|       |                        |          |            |          |           |         | Large Fab - 2               |           |             |
|       |                        |          |            |          |           |         | Large Fab - 3               |           |             |
|       |                        |          |            |          |           |         | Large Fab - 4               |           | DAS         |
|       |                        |          |            |          |           |         | Large Fab - 5               |           | 43          |
|       |                        |          |            |          |           |         | Large Fab - 6               |           | 9-89        |
|       |                        |          |            |          |           |         | Large Fab - 7               |           |             |
|       |                        |          |            |          |           |         | Large Fab - 8               |           |             |
|       |                        |          |            |          |           |         | Large Fab - 9               |           |             |
|       |                        |          |            |          |           |         | Large Fab - 11<br>(Various) |           |             |
| 110   | QC 9                   | 1<br>pcs | 7/12/19    | 7/12/19  | 0.00      | 0.00    | QC 9 - 10                   |           |             |
|       |                        |          |            |          |           |         | QC 9 - 18                   |           |             |
|       |                        |          |            |          |           |         | QC 9 - 24                   | DAS       |             |
|       |                        |          |            |          |           |         | QC 9 - 43                   | 24        | SEP 09 2019 |
|       |                        |          |            |          |           |         | QC 9 - 50                   | 9-89      |             |
|       |                        |          |            |          |           |         | QC 9 - 9                    |           |             |
| 120   | QC 5                   | 1<br>pcs | 7/12/19    | 7/12/19  | 0.00      | 0.00    | QC 5 - 10                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 12                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 17                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 18                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 19                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 22                   | DAS       |             |
|       |                        |          |            |          |           |         | QC 5 - 24                   | 24        | SEP 09 2019 |
|       |                        |          |            |          |           |         | QC 5 - 3                    | 9-89      |             |
|       |                        |          |            |          |           |         | QC 5 - 43                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 49                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 51                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 58                   |           |             |
|       |                        |          |            |          |           |         | QC 5 - 88                   |           |             |

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|                                     |       |         |      |      |                          |             |
|-------------------------------------|-------|---------|------|------|--------------------------|-------------|
|                                     |       |         |      |      | QC 5 - 9                 |             |
|                                     |       |         |      |      | QC 5 - 50                |             |
|                                     |       |         |      |      | QC 5 - 30                |             |
|                                     |       |         |      |      | QC 5 - 40                |             |
| 130 Powdercoat - 4 Black Sand - B4B | 1 pcs | 7/12/19 | 0.00 | 0.11 | Powdercoat - 1 - B4B     |             |
|                                     |       |         |      |      | Powdercoat - 2 - B4B     |             |
|                                     |       |         |      |      | Powdercoat - 3 - B4B     | BK 19-9-10  |
|                                     |       |         |      |      | Powdercoat - 4 - B4B     |             |
| 140 Handfinish - 3-1- WingWalk- B4B | 1 pcs | 7/12/19 | 0.00 | 0.75 | Handfinish - 3 - 1 - B4B |             |
|                                     |       |         |      |      | Handfinish - 3 - 2 - B4B | BE 19-09-11 |
|                                     |       |         |      |      | Handfinish - 3 - 3 - B4B |             |
|                                     |       |         |      |      | Handfinish - 3 - 4 - B4B |             |
|                                     |       |         |      |      | Handfinish - 3 - 5 - B4B |             |
| 150 QC 3                            | 1 pcs | 7/12/19 | 0.00 | 0.00 | QC 3 - 10                |             |
|                                     |       |         |      |      | QC 3 - 13                |             |
|                                     |       |         |      |      | QC 3 - 15                | AL 19-9-11  |
|                                     |       |         |      |      | QC 3 - 17                |             |
|                                     |       |         |      |      | QC 3 - 18                |             |
|                                     |       |         |      |      | QC 3 - 2                 |             |
|                                     |       |         |      |      | QC 3 - 28                |             |
|                                     |       |         |      |      | QC 3 - 3                 |             |
|                                     |       |         |      |      | QC 3 - 30                |             |
|                                     |       |         |      |      | QC 3 - 34                |             |
|                                     |       |         |      |      | QC 3 - 36                |             |
|                                     |       |         |      |      | QC 3 - 41                |             |
|                                     |       |         |      |      | QC 3 - 51                |             |
|                                     |       |         |      |      | QC 3 - 58                |             |
|                                     |       |         |      |      | QC 3 - 59                |             |
|                                     |       |         |      |      | QC 3 - 68                |             |
|                                     |       |         |      |      | QC 3 - 9                 |             |
|                                     |       |         |      |      | QC 3 - 40                |             |
|                                     |       |         |      |      | QC 3 - 19                |             |
|                                     |       |         |      |      | QC 3 - 43                |             |
|                                     |       |         |      |      | QC 3 - 24                |             |
| 160 Packaging 3-1 - Stock - B4B     | 1 pcs | 7/12/19 | 0.00 | 0.00 | Packaging 3 - 1 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 2 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 3 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 4 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 5 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 6 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 7 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 8 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 9 - B4B    |             |
|                                     |       |         |      |      | Packaging 3 - 10 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 11 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 12 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 13 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 14 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 15 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 16 - B4B   | BE 19-09-11 |
|                                     |       |         |      |      | Packaging 3 - 17 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 18 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 19 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 20 - B4B   |             |
|                                     |       |         |      |      | Packaging 3 - 21 - B4B   |             |

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|                |     |         |           |                        |  |
|----------------|-----|---------|-----------|------------------------|--|
|                |     |         |           | Packaging 3 - 22 - B4B |  |
|                |     |         |           | Packaging 3 - 23 - B4B |  |
|                |     |         |           | Packaging 3 - 24 - B4B |  |
|                |     |         |           | Packaging 3 - 25 - B4B |  |
|                |     |         |           | Packaging 3 - 26 - B4B |  |
|                |     |         |           | Packaging 3 - 27 - B4B |  |
|                |     |         |           | Packaging 3 - 28 - B4B |  |
|                |     |         |           | Packaging 3 - 29 - B4B |  |
|                |     |         |           | Packaging 3 - 30 - B4B |  |
|                |     |         |           | Packaging 3 - 31 - B4B |  |
|                |     |         |           | Packaging 3 - 32 - B4B |  |
|                |     |         |           | Packaging 3 - 33 - B4B |  |
|                |     |         |           | Packaging 3 - 34 - B4B |  |
|                |     |         |           | Packaging 3 - 35 - B4B |  |
|                |     |         |           | Packaging 3 - 36 - B4B |  |
| 170 QC 21 - SA | 1   | 7/12/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                | pcs |         |           | QC 21 - SA - 70        |  |
|                |     |         |           | QC 21 - SA - 53        |  |

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Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M138840) 1- Assemble ribs, weld as per dwg D5336 using DT10196 2- Weld Descriptions: hinge (3) and Mounting brackets as per dwg D5336 \*\*\*inspect before welding mesh\*\*\* 3- Cut mesh as per dwg D5334-1 4- Tack weld mesh on basket as per dwg D5336 \*\*\*Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) \*\*\* Mask holes and sides of hinge prior to powdercoat\*\*\* Start Time: 0:00 Oven Temperature: 500° Finish Time: 0:30 M138840

140 - (Wing Walk as per dwg QSI005 4.4 Batch 5209362) 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 5209362.

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: \_\_\_\_\_)

170 - (QC21- Final Inspection - Work Order Release)

# 010519

## Job BOM

| Part / Item    | Component Name         | Quantity            | Operation                  | Container |
|----------------|------------------------|---------------------|----------------------------|-----------|
| D2581          | Mounting Bracket       | 2 pcs (2 ea)        | 100-Large Fab - Basket - 1 | S188852   |
| D4016-3        | Hinge Half, Lid        | 3 pcs (3 ea)        | 100-Large Fab - Basket - 1 | S110937   |
| D5332-041      | Rib Assembly           | 2 pcs (2 ea)        | 100-Large Fab - Basket - 1 | S192418   |
| D5332-1        | Rib                    | 2 pcs (2 ea)        | 100-Large Fab - Basket - 1 | S127087   |
| D5332-13       | Rib                    | 3 pcs (3 ea)        | 100-Large Fab - Basket - 1 | S117495   |
| D5332-15       | Rib                    | 2 pcs (2 ea)        | 100-Large Fab - Basket - 1 | S138274   |
| D5332-19       | Rib                    | 2 pcs (2 ea)        | 100-Large Fab - Basket - 1 | S191807   |
| D5335-1        | Data Plate             | 1 pcs (1 ea)        | 100-Large Fab - Basket - 1 | SF163096  |
| M304EX0.75-16F | Expanded Metal Flat SS | 8.1600 sf (8.16 ea) | 100-Large Fab - Basket - 1 | S188430   |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 100-Large Fab - Basket - 1 | D2581          | 2        | 72        | 0         |
|                            | D4016-3        | 3        | 30        | 0         |
|                            | D5332-041      | 2        | 0         | 0         |
|                            | D5332-1        | 2        | 2         | 0         |
|                            | D5332-13       | 3        | 6         | 0         |
|                            | D5332-15       | 2        | 2         | 0         |
|                            | D5332-19       | 2        | 0         | 0         |
|                            | D5335-1        | 1        | 1         | 0         |
|                            | M304EX0.75-16F | 8        | 1,020     | 0         |

## Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. \_\_\_\_\_

|                                                |                          |                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|------------------------------------------------|--------------------------|---------------------------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| <b>Job:</b> _____                              |                          | <b>DISPOSITION</b>                                                                                      |  | <b>DEPARTMENT/PROCESS</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |
| <b>Part No.</b> _____                          |                          | Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> |  | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |
| <b>Date :</b> _____                            | <b>Sequence #:</b> _____ | <b>QTY Affected :</b> _____                                                                             |  | <b>MRB (QS1042)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |
| <b>Description Work Order Deviation</b>        |                          | <b>Disposition</b>                                                                                      |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          |                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          |                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          |                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          |                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| <b>Root Cause</b>                              |                          | <b>FAULT CATEGORY</b>                                                                                   |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Operator <input type="checkbox"/>              |                          | Positioned Wrong <input type="checkbox"/>                                                               |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Manufacturing Process <input type="checkbox"/> |                          | Outside Tolerance <input type="checkbox"/>                                                              |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Equip/Tooling <input type="checkbox"/>         |                          | Drawing <input type="checkbox"/>                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Handling/Preservation <input type="checkbox"/> |                          | Finish <input type="checkbox"/>                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Material <input type="checkbox"/>              |                          | Part Lost/Missing <input type="checkbox"/>                                                              |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Product Improvement <input type="checkbox"/>   |                          | Misread <input type="checkbox"/>                                                                        |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Process Improvement <input type="checkbox"/>   |                          | Power Loss/Surge <input type="checkbox"/>                                                               |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
| Human Factors <input type="checkbox"/>         |                          | Folio/Program <input type="checkbox"/>                                                                  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          | Grain Direction <input type="checkbox"/>                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          | Weld <input type="checkbox"/>                                                                           |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          | Wrong Stock Pulled <input type="checkbox"/>                                                             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          | Out of Sequence <input type="checkbox"/>                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          | Off-set/Set-up <input type="checkbox"/>                                                                 |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |
|                                                |                          | Other/Details: _____                                                                                    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |

Completed By

Lead hand / Supervisor

QC / QA Coordinator